

# Work Order ID 52663

October 6, 2009 7:40:02 AM

Page 1

Item ID: D2646

Accept

Revision ID: C

Item Name: Aft Cap

Start Date: 10/06/09

Start Qty: 50.00

Required Date: 10/20/09

Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 09/10/06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2646

Rev C

100

0.00



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 10531 ☐ 1-Spin as per Dwg D2646 ☐ 2-Material release note required

pl 09-10-4

110

0.00



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Ensure Material Release Note is attached

04/1/21 (50)

120

0.00



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

27 502/10/22

centro  
(+58)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52663**

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Item ID: D2646

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Setup Start



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Stop



Item Name: Aft Cap

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Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09

Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .297 as per Dwg D2646. 3-Deburr

*09/10/27 30*

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

*2) 502/10/27**cents 750*

Quality Control

150

0.00



HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

*AND 09/11/03**x30*

Hand Finishing



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52663

October 6, 2009 7:40:02 AM



Page 3

Item ID: D2646

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Setup Start



Revision ID: C

Stop



Item Name: Aft Cap

Start Date: 10/06/09

Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09

Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:30AM

FINISH TIME:

OVEN TEMPERATURE:

320°

=> 11/09/11/04 (30) 0

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

MD 09/11/13 130

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install inserts as per Dwg D2646

MD 09/11/16 130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Work Order ID 52663

October 6, 2009 7:40:02 AM



Page 4

Item ID: D2646

Accept



Setup Start



Revision ID: C

Stop



Item Name: Aft Cap

Start Date: 10/06/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/20/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

→ Serial 16

10/10/09  
50

30

BR09-11-16

09/11/16

mf  
09-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

October 6, 2009 7:40:01 AM

Page 1

Work Order ID: 52663

Parent Item: D2646RevC

Parent Item Name: Aft Cap

Comments:



Start Date: 10/06/09

Required Date: 10/20/09

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			110	Each	3,056.000	100.0000			



Insert



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

105855

108606

111529

111779

112772

3056

16

52

1488

500

1000

D2646PRevC

Purchased

No

180

Each

0.0000

50.0000



Aft Cap



X60 MD 09/11/13

209/11/16



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

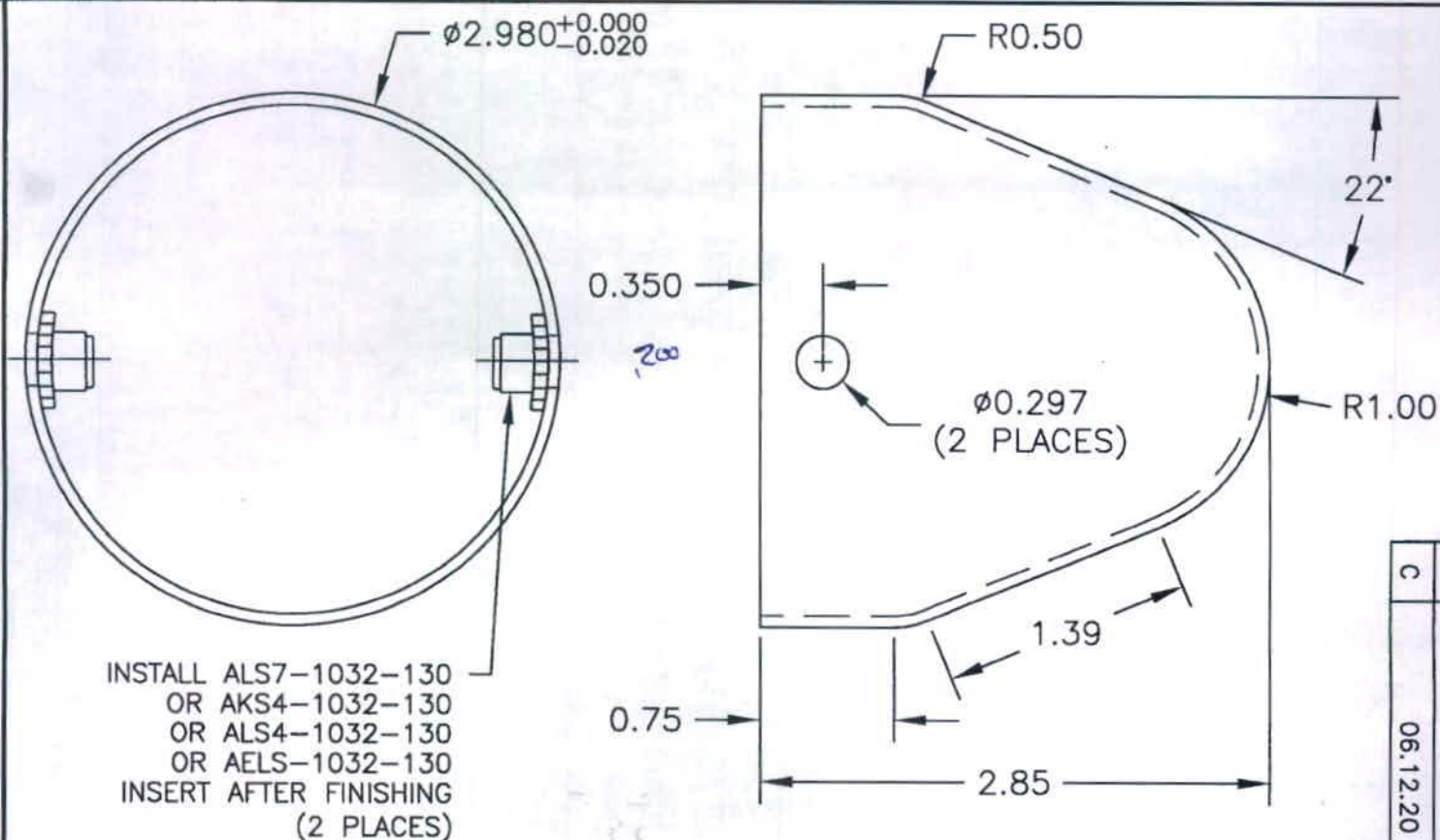
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	
CHECKED		APPROVED		DRAWING NO.	D2646
				REV. C	SHEET 1 OF 1

DATE	TITLE	SCALE
06.12.20	AFT CAP	1:1
A	97.03.25	NEW ISSUE
B	05.04.01	CHANGE TO CLOSED INSERTS
C	06.12.20	CHANGE TO OPEN ENDED INSERTS



1) MATERIAL: ALUMINUM 1100-O 0.063 THICK (QQ-A-250/1)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

07-02-12 ~~OK~~

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52663

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**Sieg's Manufacturing Ltd.**  
Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7  
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

**Packing Slip**

Packing Slip No.:

37189

Date:

10/20/2009

Page:

1

<b>Sold to:</b>	<b>Ship to:</b>
DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 10531	<b>Sold By:</b> KAULBARS, KALE
<b>Shipped By:</b> Ted ex.	<b>Ship Date:</b> 10/20/2009
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
D2646P +	EACH	AFT CAPS  S 6/10/22	✓ 50

**Comment:**







Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET LANGLEY B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

## INSPECTION REPORT

Date: Oct. 20/09

Customer: Dart Aerospace

Packing Slip: 37189

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
D2646P	50	4GA	N/A	✓	R

Notes:

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Material Certification Attached: Yes.



## PRECISION COIL, INC.

Post Office Box 2650  
U.S. 50 West  
Clarksburg, WV 26302  
(304) 622-1984  
(304) 622-2301

7/10/2007

CS 1775

## CERTIFIED INSPECTION REPORT

Report No. 31657

Test Date 7/10/2007

Lot # / Heat # / S/O # 76086

Alloy 1100

Temper O

Gauge (in) .063

Width (in) 48

Length (in) 144.000

Net Weight (lbs) 10,522# 'S

Customer Name COPPER &amp; BRASS SALES

Customer PO # CS1775

Test Specification AMSQQA250/1A &  
ASTMB209-06

S on 10/12/07

Test No	Spec ID	YLD (psi)	UTS (psi)	ELONG in 2" (%)
38480	1100-O	5,714	13,038	33.00

ALLOY	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHER		Al
									EACH	TOTAL	
1100	Si+Fe	=.95	.05-.20	.05	---	---	.10	---	.05	.15	99.00 Min
ACTUALS											
	.12	.60	.10	---	---	---	.01	---	.05	.15	REMAINDER

THIS REPORT INDICATES THE CHEMICAL ANALYSIS RANGE TO WHICH THE ITEMS LISTED WERE MANUFACTURED  
BASED ON CERTIFICATE OF COMPLIANCE FURNISHED TO US BY THE PRODUCER. WE CERTIFY THEM TO BE  
WITHIN THE LIMITS SHOWN. FOR ALLOY 1350 ONLY A MINIMUM ELECTRICAL CONDUCTIVITY OF 62% I.A.C.S.  
AT 20 DEGREES CELSIUS IS GUARANTEED.

By:

UNCLY

Date:

7/13/07







Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO10531

Purchase Order Date 06/10/2009

PO Print Date 06/10/2009

Page Number 1 of 1

Order From :

VC-SIE001

SIEG'S MANUFACTURING LTD.  
6236 - 205 STREET  
LANGLEY, BC V2Y 1N7  
CA

Contact Name  
Vendor Phone 604 530 7455  
Vendor Fax 604 530 7490  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms Net 30  
Currency CAD  
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2646P C	Aft Cap	06/10/2009 Yes	50.00 Each	Yours ppd	\$5.3500	\$267.50

Special Inst: As per DWG D2646 Rev C

PO Total:

\$267.50

**FAKED**  
06-10-09  
297

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 06/10/2009

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

